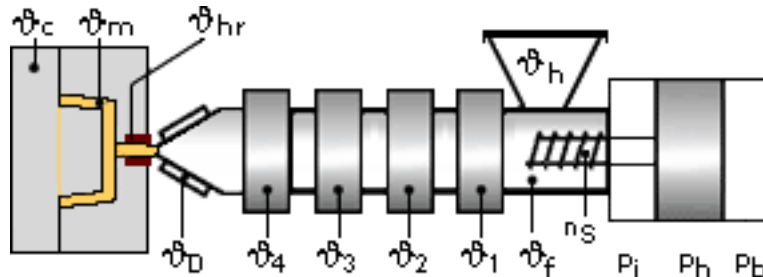


CELSTRAN® PBT-GF30-08 | PBT | Glass Reinforced

Description

30% Long Glass Fiber Reinforced PBT

Typical injection moulding processing conditions



Pre Drying:

CELSTRAN PBT should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be $\leq -30^{\circ}\text{C}$. The time between drying and processing should be as short as possible

Temperature:

	Feed
min ($^{\circ}\text{F}$)	68
max ($^{\circ}\text{F}$)	122

Injection Molding

Celstran can be processed on a standard injection molding unit.
A general purpose metering screw is recommended with a zone distribution of 40% feed, 40% transition, and 20% metering.
A free flowing check ring assembly is recommended.

Melt Temp.: $280 - 300^{\circ}\text{C}$.

Mold Temp.: $80 - 90^{\circ}\text{C}$.

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